



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6405G00332-3G
Job Sheet 184941



Part No: RBW6405G00332-3G

Job Qty: 2 ea

Part Name: Tail Rotor Pitch Control Adjustment Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/18/18

Job Tracking No:

Due Date: 11/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6405G00332-3G Rev. 5 IPP Rev. A 18.09.24 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		11/16/18	0.00	0.00	Start Up Small Fab-4		M.D.
100	Small Fab	2 pcs		11/16/18	0.00	1.00	Small Fab-9		M.L.L. DAS
110	QC	2 pcs		11/16/18	0.00	0.00	QC5		30
120	QC	2 pcs		11/16/18	0.00	0.00			9-89
130	Packaging	2 pcs		11/16/18	0.00	0.00	Packaging3-2		Dave R.
140	QC21-FG	2 Ea		11/16/18	0.00	0.00	QC21		

Part Op 100 - Assemble as per DWG.
Descriptions: 130 - Identify and Stock

DAS DEC 19 2018

GA097 21 9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
61 90081A077	Drive Screw #2 1/4" Long	8 Ea (4 ea)	90-Start up Operation	5048890
52 91732A233	Threaded Insert 5/16-24 Unf X 15/32	8 Ea (4 ea)	90-Start up Operation	5122149
54 92373A149	Roll Pin 3/32" X 1"	4 (2 ea)	90-Start up Operation	5122116
5T349 AN3-7A	Bolt	2 Ea (1 ea)	90-Start up Operation	5089286
5T339 AN5-5A	Bolt	4 Ea (2 ea)	90-Start up Operation	fm133363
5T322 AN960-516	WASHER SEE PART NAS1149F0563P	4 pcs (2 ea)	90-Start up Operation	5041158
RB41011	Dart Tooling Placard, Aluminum	2 Ea (1 ea)	90-Start up Operation	5021040
RBW6405G00332-3G-1	Base NV5000	2 Ea (1 ea)	90-Start up Operation	5131281
RBW6405G00332-3G-11	Pointer	2 Ea (1 ea)	90-Start up Operation	5131618
RBW6405G00332-3G-3	Round Seat SL-154	2 Ea (1 ea)	90-Start up Operation	5132447
RBW6405G00332-3G-5	Stud SL-154	4 Ea (2 ea)	90-Start up Operation	5132065
RBW6405G00332-3G-7	Slide Seat NV5000	2 Ea (1 ea)	90-Start up Operation	5132499
RBW6405G00332-3G-9	Knob	4 Ea (2 ea)	90-Start up Operation	5132774
SKN-55	Thumb Nut Ss	2 Ea (1 ea)	90-Start up Operation	5107890

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	90081A077	8	88	0
	91732A233	8	20	0
	92373A149	4	0	0
	AN3-7A	2	363	0
	AN5-5A	4	125	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

AN960-516	4	282	0
RB41011	2	741	0
RBW6405G00332-3G-1	2	0	0
RBW6405G00332-3G-11	2	0	0
RBW6405G00332-3G-3	2	0	0
RBW6405G00332-3G-5	4	0	0
RBW6405G00332-3G-7	2	0	0
RBW6405G00332-3G-9	4	0	0
SKN-55	2	10	0

Part Specifications

Specifications could not be found.

Plex 10/18/18 3:24 PM Dart.lajeunesse.marie



Container No: S138656



Part: RBW6405G00332-3G

Job No: 184941

Serial No/Batch: S138656

Revision: 5

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 12/19/18

DQA: _____ Date: _____



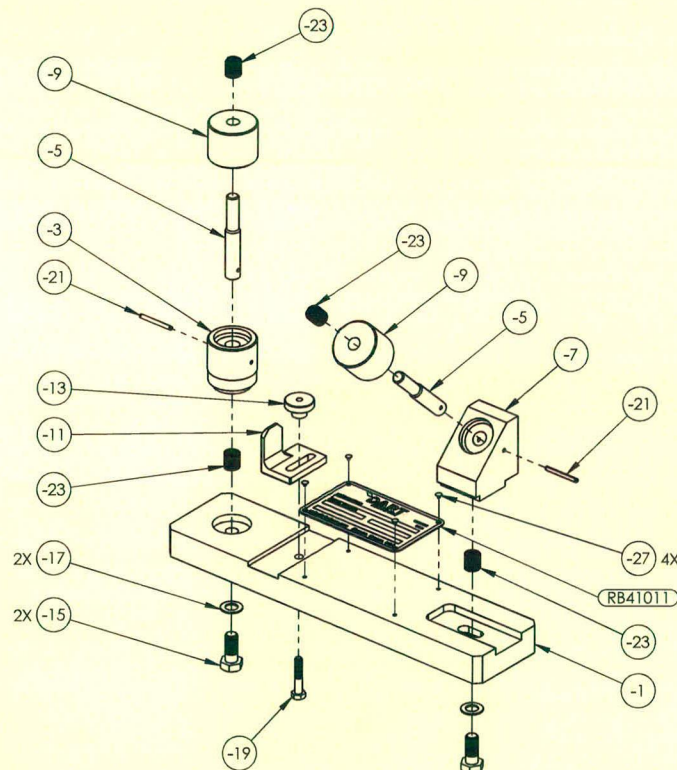
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

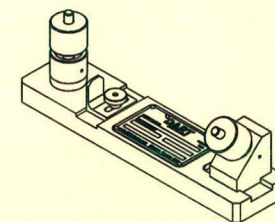
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
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Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :																							
Misidentified ☐	Past Due ☐																								

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		-1 CHD ENGRAVE NOTE.	5/28/2009	RJC	RW
1		-1 CHD LOWER C.B. FROM Ø.981. ADDED MISSING DIM 1.375, CHD FINISH SPEC. DELETED ENGRAVE NOTE. -5 CHD FINISH SPEC. ADDED MISSING HOLE DIM. -7 ADDED MISSING DIM FOR HOLE & CHD DIMS FOR HOLE LOCATION. DELETED .754 DIM. ADDED ENGRAVE NOTE, CHD FINISH SPEC. -3, -9 & -11 ADDED ENGRAVE NOTE, CHD FINISH SPEC.	5/4/2011	RJC	
2		-1 ADDED 4X Ø.089 HOLES, CHD FROM POWDER COAT TO RED ANODIZE. -3 CHD B/O INFO FROM Ø1-3/8 TO Ø1-1/4, CHD O.D. FROM 1.230 TO 1.25. -7 ADDED MISSING R.062 DIM. ADDED 1.584 AND 370 DIMS.	9/24/2012	JAG	
3		-1 REMOVED MASKING ANNOTATIONS AND ASSOCIATED NOTES. -5 CHD DIM WAS Ø.372 BASIC IS Ø.374 AND LIMITS. -7 ADDED LIMITS TO Ø.374 DIM. ADDED LOCATION DIM FOR Ø.098 HOLE (1.057).	2/5/2013	BIM	GE
4	15-0298	-3 CHD ENGRAVE NOTE WAS ENGRAVE T/N IS ENGRAVE P/N. CHD DIM WAS Ø.094 IS Ø.097 - .094. -5 CHD DIM WAS Ø.094 IS Ø.097 - .094. CHD MATERIAL CALLOUT WAS 4140 G&P B 4140 G&P / 4142 G&P. -7 CHD ENGRAVE NOTE WAS ENGRAVE T/N IS ENGRAVE P/N. CHD DIM WAS Ø.094 IS Ø.097 - .094. -9 CHD ENGRAVE NOTE WAS ENGRAVE T/N IS ENGRAVE P/N. -11 CHD ENGRAVE NOTE WAS ENGRAVE T/N IS ENGRAVE P/N.	9/14/2015	RJC	JAG
5	16-0233	-1 CHD DIMS WAS Ø.323 THRU L. -1 Ø.978 ±.20 S.F. -3 IS Ø.323 THRU ALL L. -1 Ø.978-9792 ±.20 (S.F. -3). WAS .986 S.F. -11 IS .986 ±.002 (S.F. -11). WAS .988 S.F. -7 IS .988 ±.002 (S.F. -7). WAS 1.375 IS (1.375). DELETED DIMS .627, 2X R.196 ±.24, 2X Ø.98 ±.40, 2X R.164 THRU, 3.690. ADDED DIMS .24, .40, .335, .392, 2X FULL R. .328, .98, 2X FULL R. 2X R.20. -3 CHD DIMS WAS Ø.374 S.F. -5 IS Ø.3738-3747 (S.F. -5). WAS Ø.094-.097 IS Ø.094-.097 THRU ALL (P.F. -21). WAS Ø.328 FOR -23 HELICOIL IS TAP FOR -23 5/16-24 HELICOIL INSERT = 1.5" DIA. WAS Ø.977 S.F. -1 IS Ø.9756-9764 (S.F. -1). -5 CHD DIMS WAS Ø.374 - .0012 - .0019 IS Ø.3721-.3728 (S.F. -3 & -7). WAS Ø.094-.097 THRU IS Ø.094-.097 THRU ALL (P.F. -21). WAS .914 IS .914 ±.010. CHD MATL WAS 4140 G&P / 4142 G&P IS 4140/4142. ADDED HEAT TREAT RC 28-34, CHD FINISH WAS CAD PLATE YELLOW G&P-416, TYPE B, CLASS B ZINC PLATE ASTM B633 TYPE 15C2. -7 CHD DIMS WAS Ø.234 THRU ALL L. -1 Ø.374 ±.0007-.0000 ±.75 S.F. -5 IS Ø.234 THRU ALL L. Ø.3738-3747 ±.75 (S.F. -5). WAS Ø.094-.097 THRU IS Ø.094-.097 THRU ALL (P.F. -21). WAS Ø.328 ±.50 FOR -23 HELICOIL IS TAP FOR -23 5/16-24 HELICOIL INSERT = 1.5" DIA. WAS .980 S.F. -1 IS .980 ±.002 (S.F. -1). WAS .430 IS (.430). -9 CHD DIM WAS Ø.328 THRU ALL FOR -23 HELICOIL IS TAP FOR -23 5/16-24 HELICOIL INSERT = 1.5" DIA. -11 CHD DIM WAS .981 S.F. -1 IS .980 ±.002 (S.F. -1). DELETED DIM R.103. ADDED DIMS .206, 2X FULL R. -27 CHD B/O REF WAS Ø.1 X 1/8 #90081A074 IS #2 X 1/4 (#90081A077).	11/28/2016	DPD	SM



NOTES:
ORIGINAL REF. No.
RBW640G00332 ASSY. = 3G6405G00332
RBW6405G00332-1 = 3G6405G01252
RBW6405G00332-3 = 3G6405G06431
RBW6405G00332-7 = 3G6405G06531
RBW6405G00332-9 = 3G6405G06631
RBW6405G00332-11 = 3G6405G01652
DO NOT USE. FOR REFERENCE ONLY

SHOP COPY
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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 184941
18-10-18

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	BASE	6061		2
			-3	1	ROUND SEAT	6061		3
			-5	2	STUD	4140/4142		4
			-7	1	SLIDE SEAT	6061		5
			-9	2	KNOB	6061		6
			-11	1	POINTER	6061		7
		B/O	-13	1	THUMB NUT	S.S.	#10-32 UNF (ESSENTA #5KN-55)	1
		B/O	-15	2	HEX HEAD CAP SCREW	STEEL	5/16-24 UNF (SPENCER AIRCRAFT #ANS-SA)	1
		B/O	-17	2	FLAT WASHER	STEEL	Ø5/16 (SPENCER AIRCRAFT #AN940-516)	1
		B/O	-19	1	HEX HEAD CAP SCREW	STEEL	#10-32 UNF X 7/8 (SPENCER AIRCRAFT #AN3-7A)	1
		B/O	-21	2	ROLL PIN	S.S.	Ø3/32 X 1 (MCMASTER-CARR #92373A149)	1
		B/O	-23	4	HELI-COIL	S.S.	5/16-24 UNF X 1/2 (MCMASTER-CARR #91732A233)	1
		B/O	-27	4	#2 DRIVE SCREW	COATED STEEL	#2 X 1/4 (MCMASTER-CARR #90081A077)	1
		B/O		1	DART PLACARD	ALUMINUM	RB41011	1

DART AEROSPACE	
TITLE T/R PITCH CONTROL LINK ADJUSTING TOOL	
DWG NO. RBW6405G00332-3G	REV 5
MAT'L. _____ FINISH _____ SPEC _____ DRAWN BY: PERRITT CHECKED: CLOUGH APPR: ANDERSON QA APPR: LINDSAY APPROVED: MACKOVJAK SCALE 1:3	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES ± 125/ 1. BREAK ALL SHARP EDGES .015 X .45° OR .JIS 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 USED ON MODEL AGUSTA DATE 1/13/2008 SHEET 1 OF 7	

